

Form: rprocess

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Tuesday, 04/03/2008 1:46:31 PM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 37677

Part Number: D32111

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Bend D3211-1 Stack as per Dwg D3211

88 08/03/05 P10 (7)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/03/05 (+7)

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

BR 08-03-06

(7)

9.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

M100700

M-1 08/03/06

(7x)

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-03-06

(x7)

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 212

AS 08/03/06

(x7)

12.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/03/07

(7)

Job Completion



2008/3/07

(7)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		Grain direction needs to be changed to 45 degrees due to bending on all H sides				<i>AB</i> 08/03/05	<i>AB</i> 08/03/05

Part No: D3211-1 PAR #: N/A Fault Category: Prod / fab. ass. <sup>med & small</sup> NCR: Yes No DQA: 12 Date: 08/03/07  
 QA: N/C Closed: 12 Date: 08/03/10

NCR: <u>37677</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/03/05	6	3 piece broke at the bend	<i>AB</i> 08/03/05	Swaps clusters NO replace	<i>AB</i> 08/03/05	<i>AB</i> 08/03/05	<i>AB</i> 08/03/05	<i>AB</i> 08/03/05

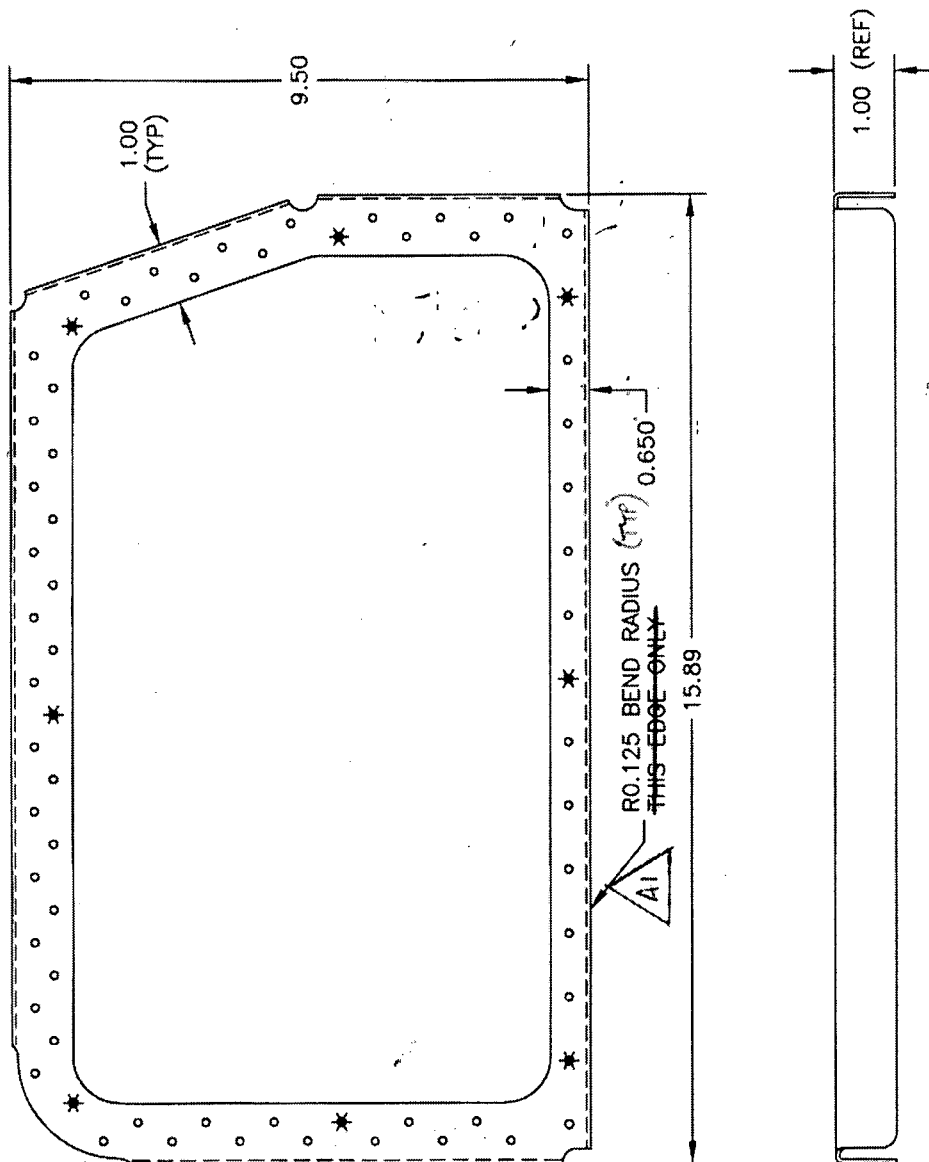
NOTE: Date & initial all entries



DESIGN	10	DRAWN BY	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	HA	APPROVED	HA	DRAWING NO. D3211	REV. A SHEET 1 OF 2
DATE	03.09.03			TITLE BRACKET	SCALE 1:3
A	03.09.03			NEW ISSUE	
A1	HA 03.12.05			CHANGE ALL BEND RADIUS TO R0.125	

RELEASED  
03.09.05

D3211-1 BRACKET  
MACHINE PER DRAWING FILE "D3211-A2.DWG"  
CHECK PER TEMPLATE D3211-1T1  
MATERIAL: 2024-T3 (QQ-A-250/4) SHEET 0.063 THICK  
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1  
POWDER COAT BLACK SANDEX (4.3.5.7) PER DART QSI 005 4.3  
USE MINIMUM BEND RADIUS OF 0.125, EXCEPT WHERE INDICATED 0.125  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



WLO  
37677

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DART AEROSPACE LTD		Work Order:	37677
Description: BRACKET		Part Number:	D3211-1
Inspection Dwg: D3211-1 Rev: A1		Page 1 of 1	

## FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article**      ☐ **Prototype**

[illegible]

Measured by: <b>IB</b>	Audited by: <b>[Signature]</b>	Prototype Approval: <b>[Signature]</b>
Date: <b>8-3-4</b>	Date: <b>08/03/05</b>	Date: <b>14</b>

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	